

Date: Monday, 02/06/2008 9:28:32 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE SOCKET
Job Number	: 39460		
Estimate Number	: 11210		
P.O. Number	:	Part Number	: D333017
This Issue	: 02/06/2008 S.O. No. :	Drawing Number	: D3330 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 23/05/2008 Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 35484	Material	:
Written By	<i>[Signature]</i>	Due Date	: 15/06/2008 Qty: ¹² Um: Each
Checked & Approved By	:		
Comment	: Est A 05.01.13 New issue KJ/JLM est B 07.05.14 rev C dwg EC est D 07.12.12 Rev D dwg EC verified by:DD Est Rev:E Now on Doosan Lathe 08-06-02 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1025TR1125W125	1025 Steel Bar
-----	-----------------	----------------



Comment: Qty.: 0.2187 f(s)/Unit Total : 1.3123 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 1.125" dia tubing, 0.125" wall

(M1025TR0.875W.125)

Batch: *M16634**20 08/06/02*

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: DOOSAN LATHE

Turn as per Folio FA490 and Dwg D3330

20 08/06/02

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 18/06/02

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

21/08.06.05 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W5 22**21 08/06/05 (12)*

Date: Monday, 02/06/2008 9:28:32 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE SOCKET

Job Number: 39460

Part Number: D333017

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

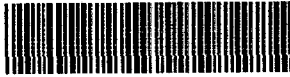
FINAL INSPECTION/W/O RELEASE



08/06/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

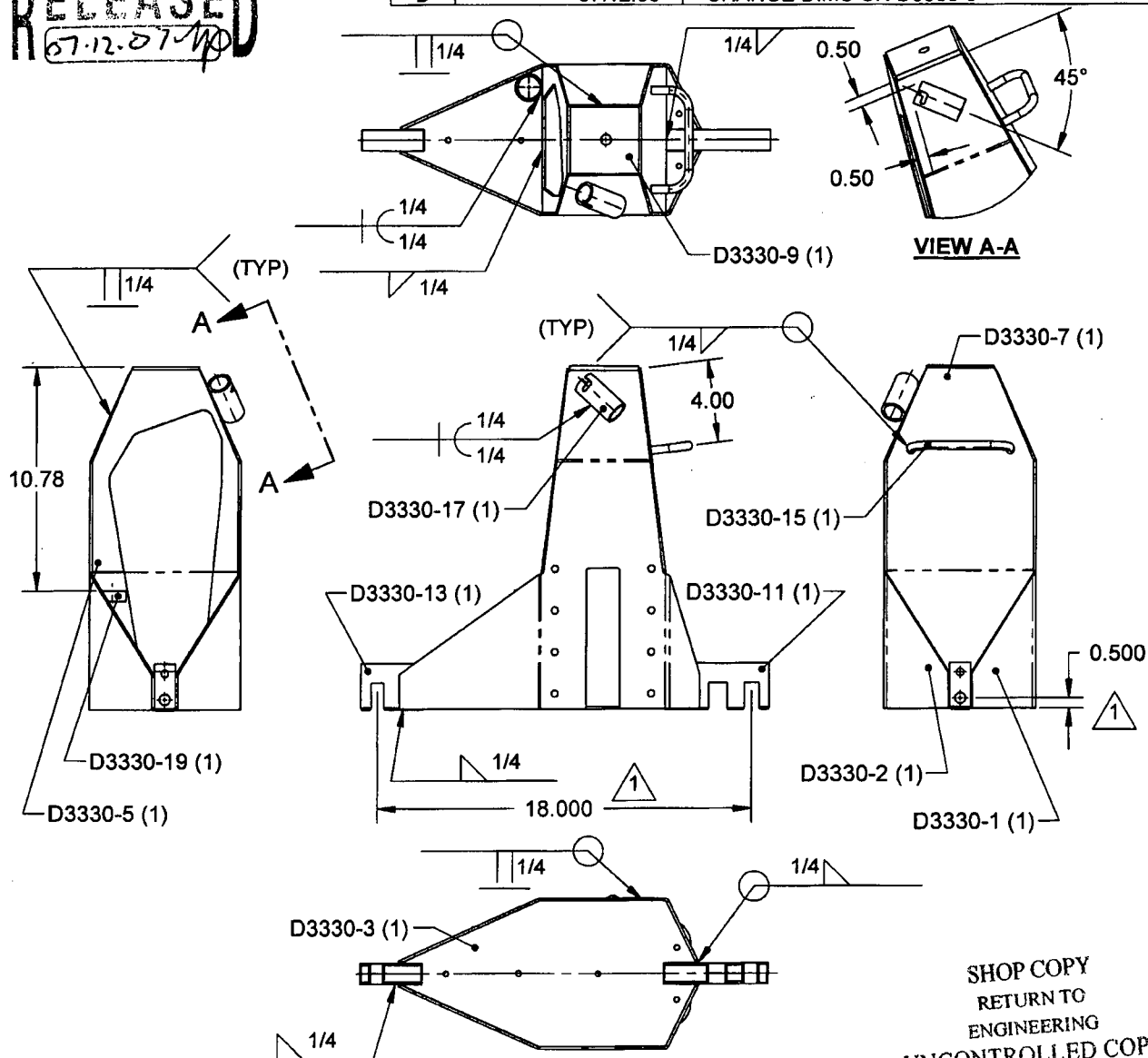
Job Completion



mf 08-06-06
cL

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

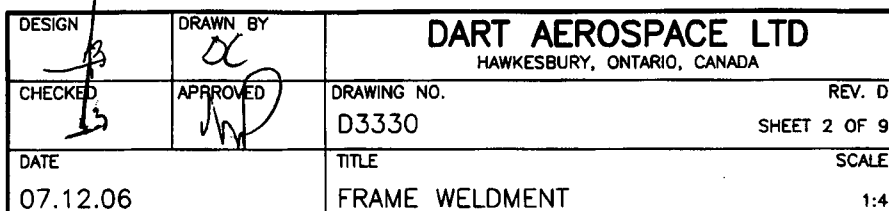
**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

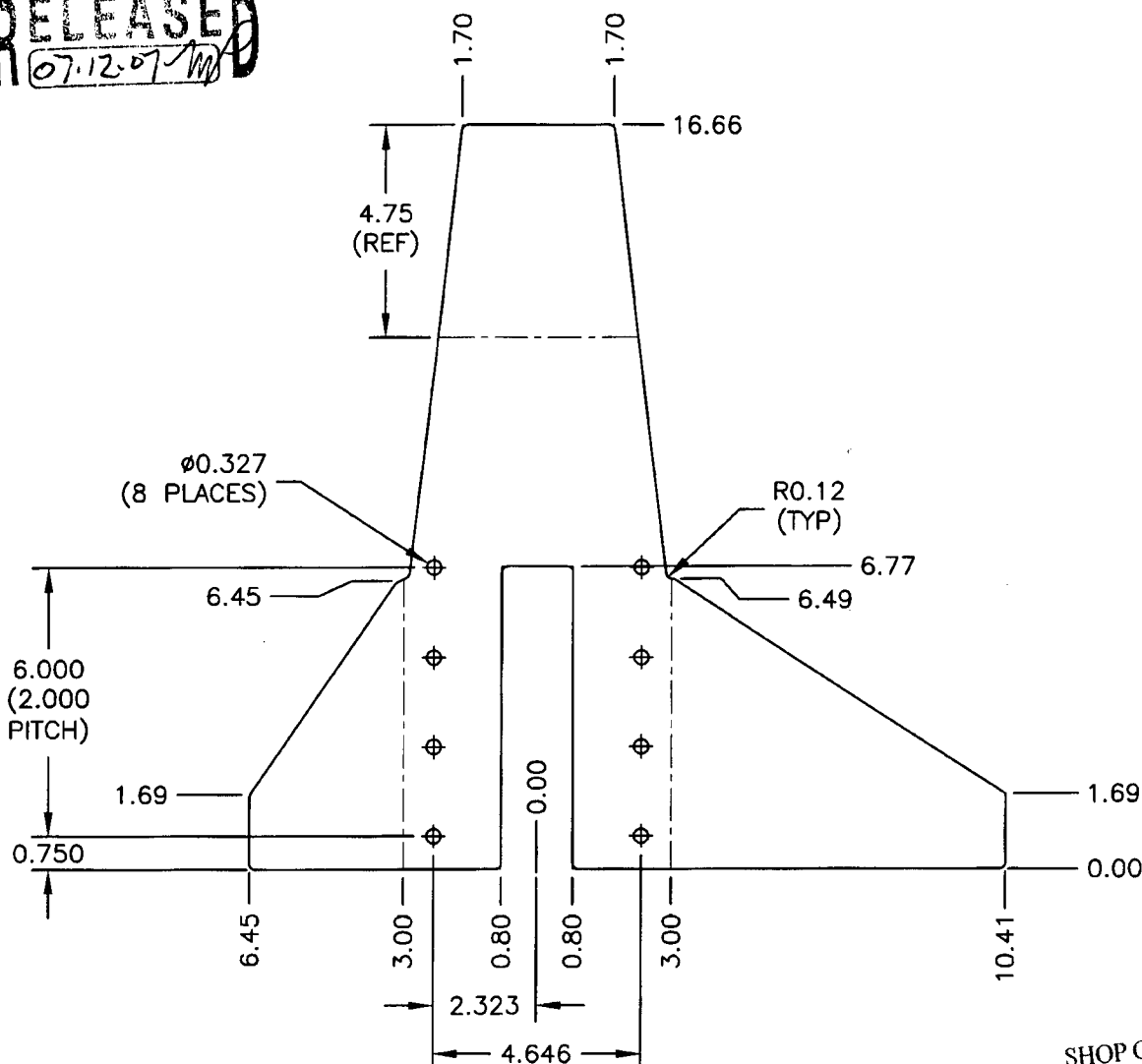
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D3330-1 PANEL

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, NO 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

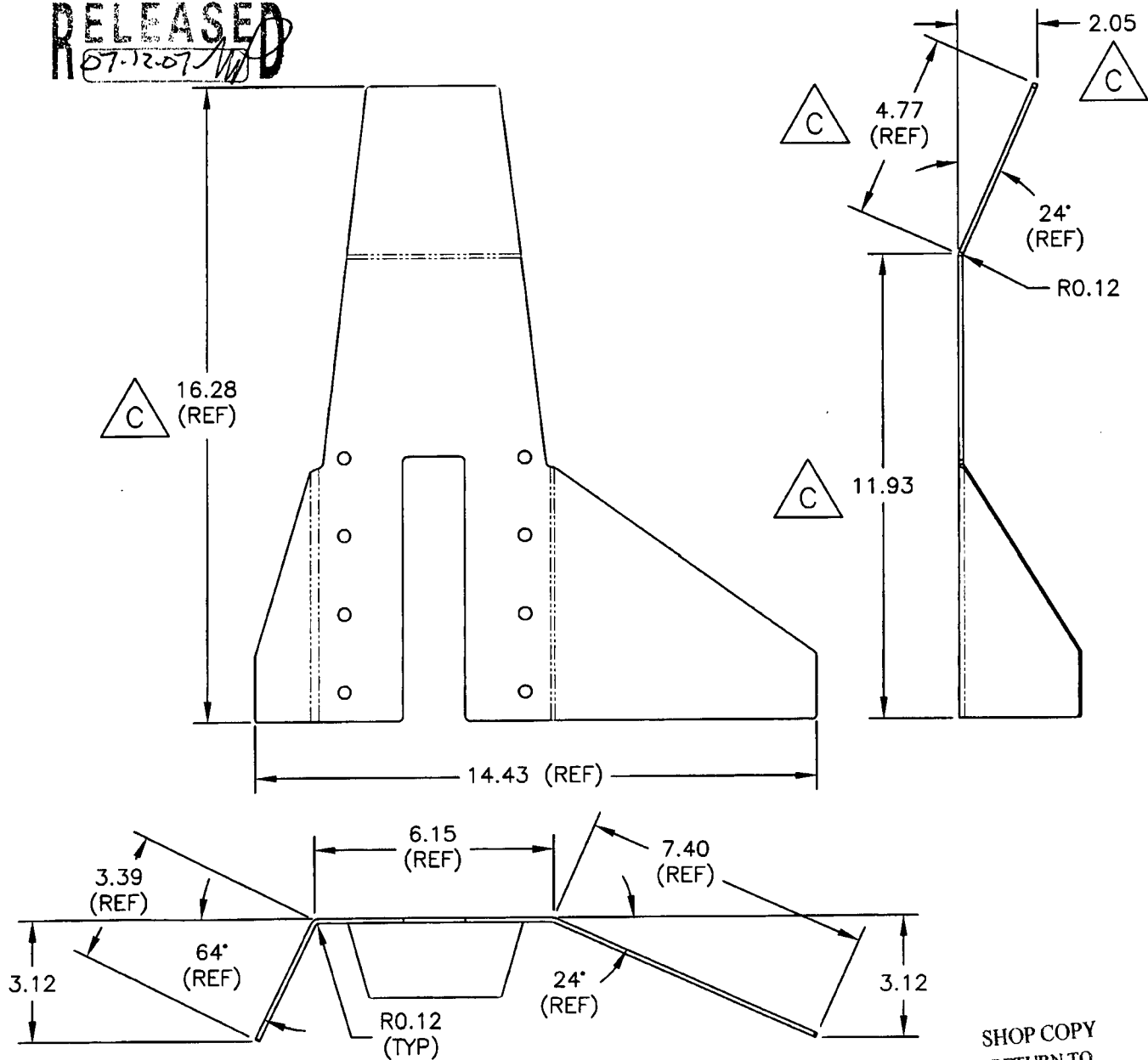
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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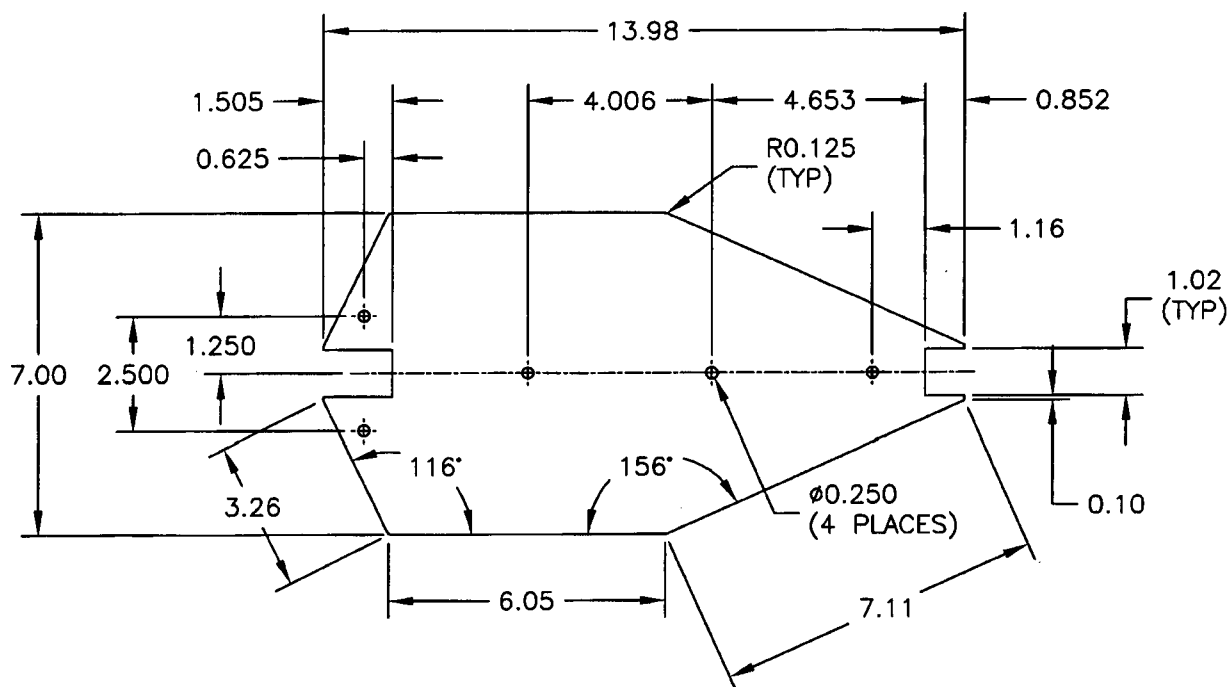
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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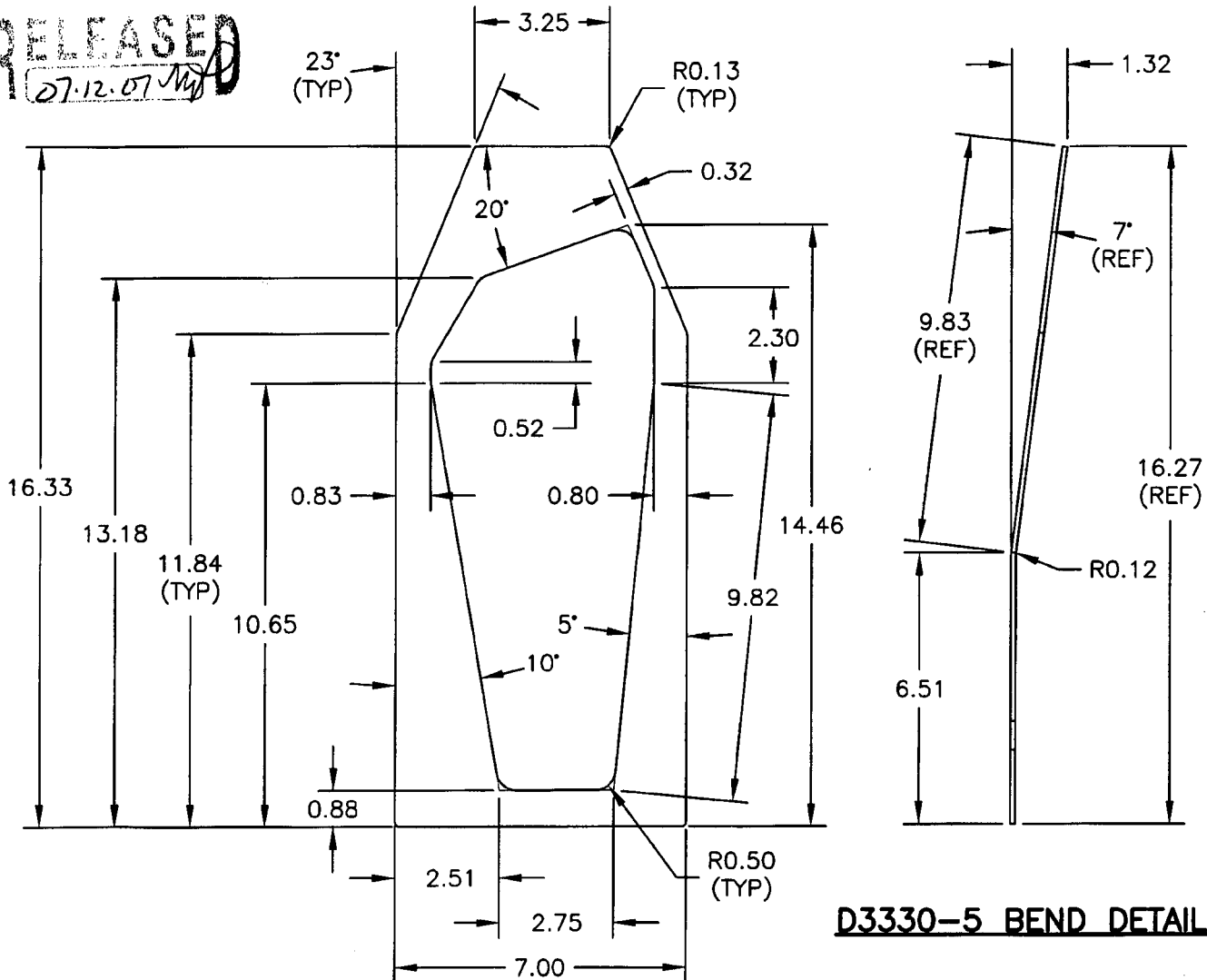
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07.12.07 *MD*

**D3330-5 BEND DETAIL****FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, UNCONTROLLED COPY 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) SUBJECT TO AMENDMENT
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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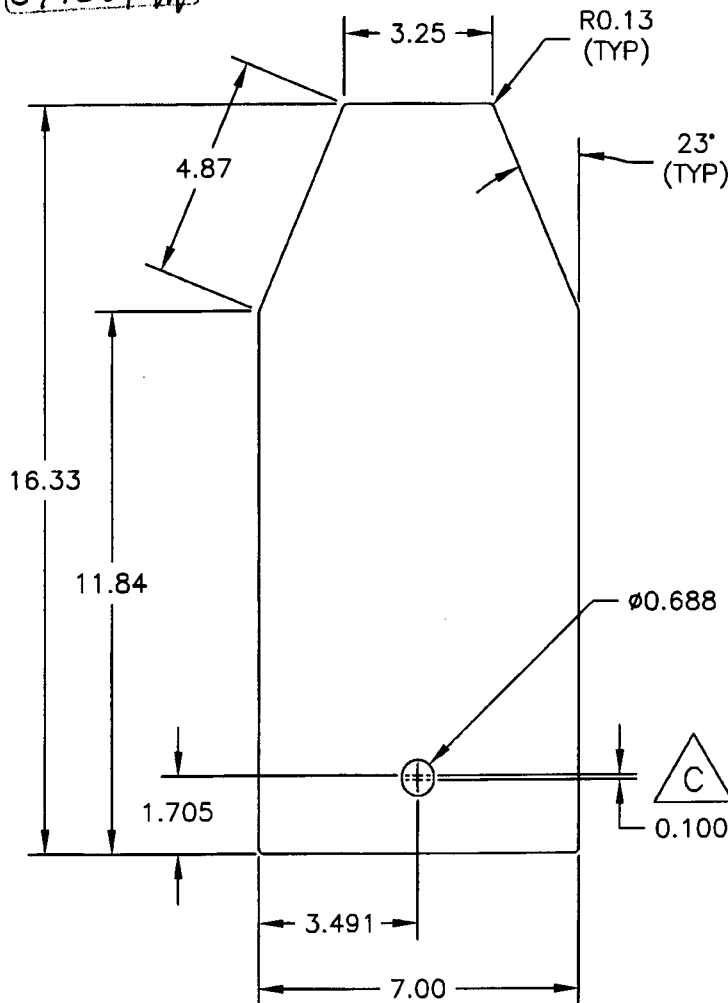
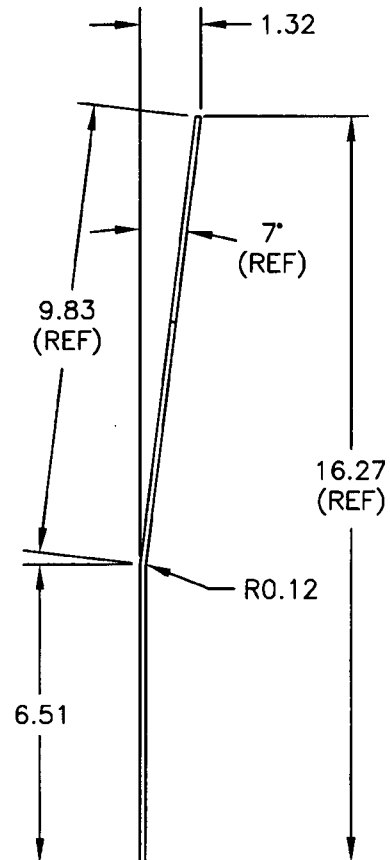
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07.12.07 *[Signature]***FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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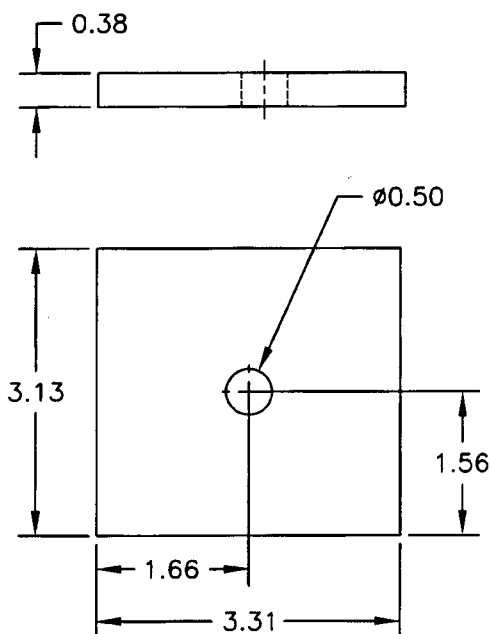
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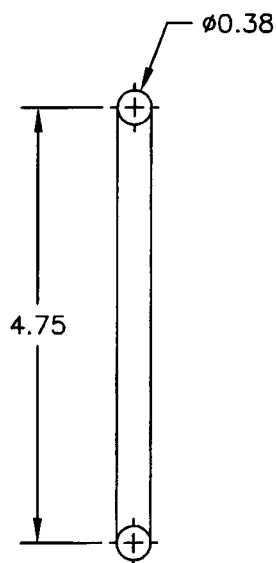


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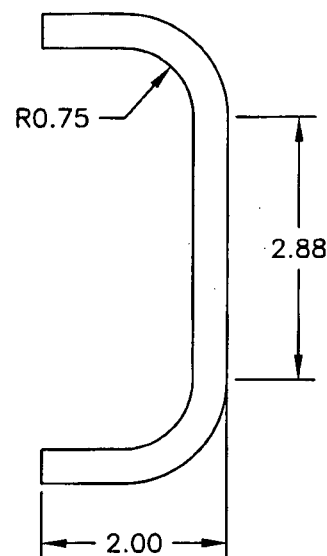
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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

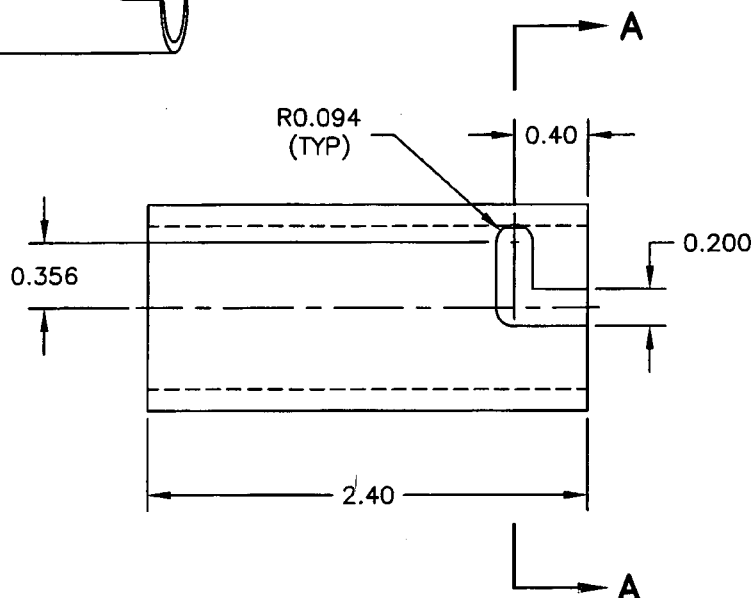
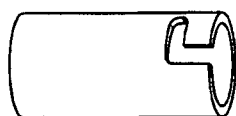
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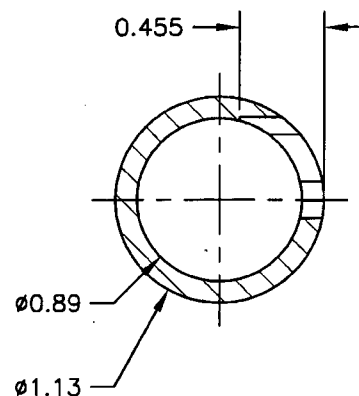
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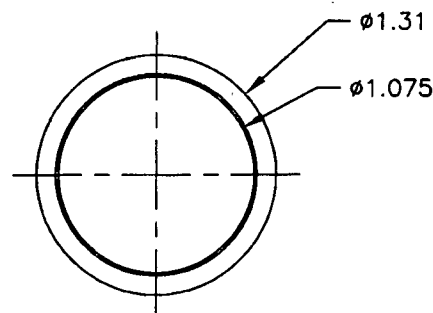
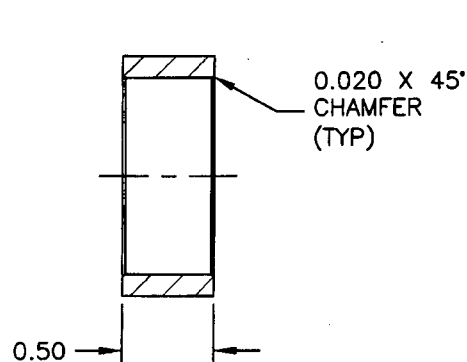


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

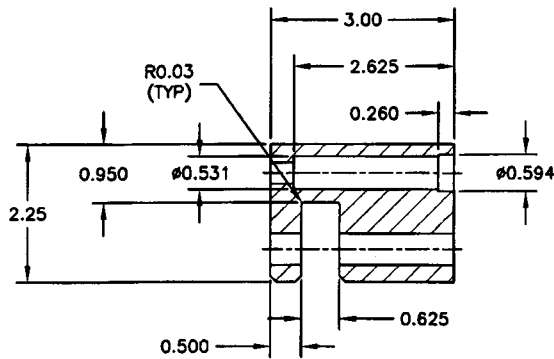
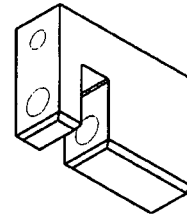
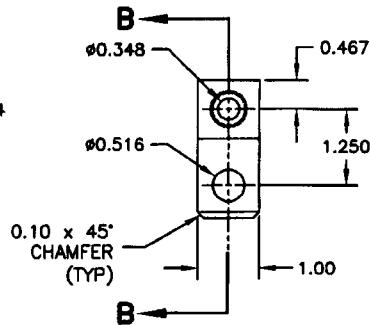
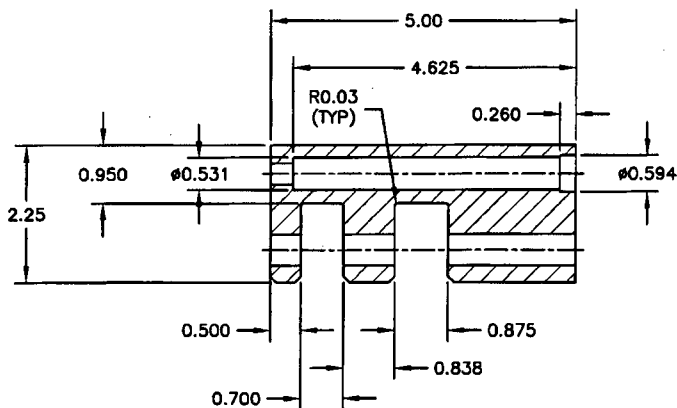
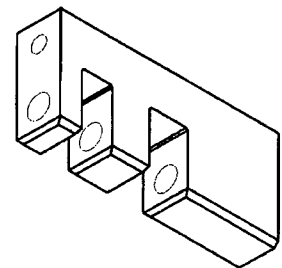
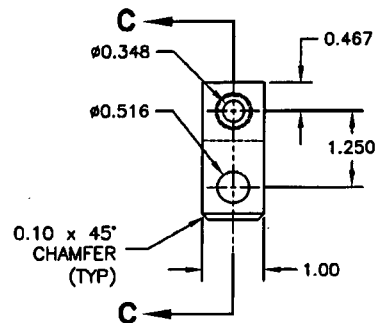
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RELEASED
07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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